

Work Order ID 77614

December-13-11 4:26:00 PM

77614

Page 1

Item ID: D3564-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 13/12/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D Prog
304 QC3 Rev: Q 2-Deburr if necessary 12

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control 12

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 05/01/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC10- Inspect visual per QSI004- ground welds	0.00							
160									
QC	Memo	0.00		8	12/01/02				
Quality Control									

170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00		5	12/01/02				
Quality Control									

180	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
180									
Powdercoat									
Powder Coating									

Memo
START TIME: 11:00 OVEN TEMPERATURE:
FINISH TIME: 11:30

3200F

12x4 m/l 12/01/02

M118489

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NOTE: Date & initial all entries

Picklist Print

December-13-11 4:26:05 PM

Page 1

Work Order ID: 77614

77614

Parent Item: D3564-11

D3564-11

Parent Item Name: Wearshoe

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ
Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	150.8300	1.41	17.81053			
M304S16GA									**				
304/316 Sheet .063													

1811-12-22

Location

Loc Qty

Loc Code

MAT020

150.83

119653

150.83

119653

12

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	77614
Description: Wearshoe		Part Number:	D3564-11
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.230	✓		V IB02	
2.432	+/-0.010	2.440	✓		V	
2.50	+/-0.030	2.50	✓		T IB01	
6.000	+/-0.010	6.000	✓		T	
12.104	+/-0.010	12.104	✓		T	
18.000	+/-0.010	18.000	✓		T	
18.00	+/-0.030	18.00	✓		T	
9.00	+/-0.030	9.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
0.300 x 0.300	+/-0.010	301x300	✓		V	
Ø0.188	+0.005/-0.001	.190	✓		V	
R0.375	+/-0.010	.375	✓		R.G.	
0.063	+/-0.010	.059	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-12-22	Date: 11/12/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	

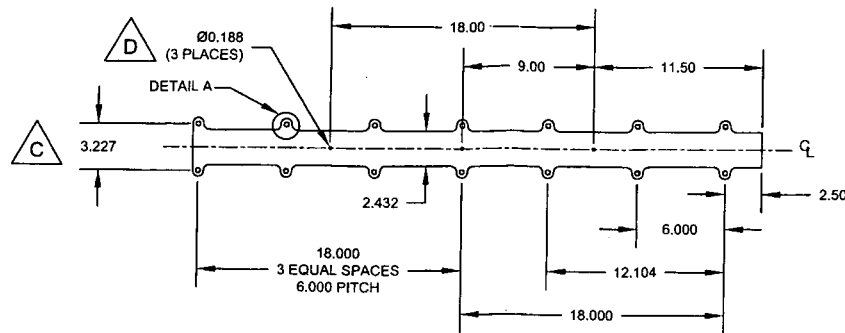
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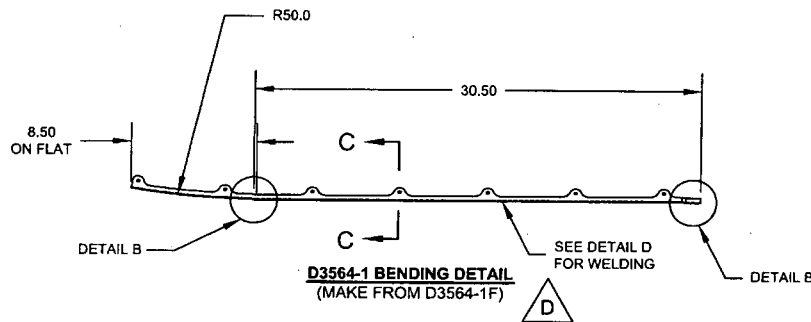
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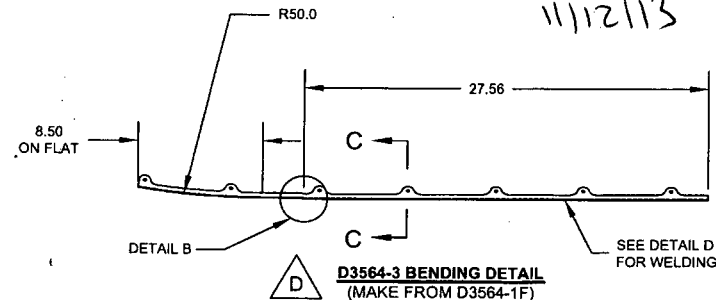
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RELEASED

07.09.04

UNDER REVIEW

OK 9/11/12

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT Q

WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3564 TITLE WEARSHOE SCALE 1:8 REV. D SHEET 1 OF 3 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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NOTE: Date & initial all entries

This technical drawing provides detailed specifications for aircraft wearshoe components, including flat patterns and bending details for two different models.

D3564-5F FLAT PATTERN

- Overall length: 43.50
- Overall width: 30.00
- Top flange width: 20.00
- Top flange thickness: 2.50 (REF)
- Bottom flange width: 38.50
- Bottom flange thickness: 2.432
- Bottom flange pitch: 7 EQUAL SPACES 5.500 PITCH
- Bottom flange diameter: Ø0.188 (4 PLACES)
- Detail A: 10.00
- Detail B: 2.50 (REF)
- Detail C: 6.75
- Detail D: 3.227

D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)

D3564-7F FLAT PATTERN

- Overall length: 28.50
- Overall width: 23.50
- Top flange width: 10.00
- Top flange thickness: 2.50 (REF)
- Bottom flange width: 23.50
- Bottom flange thickness: 2.432
- Bottom flange pitch: 4 EQUAL SPACES 5.875 PITCH
- Bottom flange diameter: Ø0.188 (2 PLACES)
- Detail A: 9.25
- Detail B: 2.50 (REF)
- Detail C: 2.50
- Detail D: 3.227

D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)

D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)

- Overall length: 43.50
- Overall width: 30.00
- Top flange width: 20.00
- Top flange thickness: 2.50 (REF)
- Bottom flange width: 38.50
- Bottom flange thickness: 2.432
- Bottom flange pitch: 7 EQUAL SPACES 5.500 PITCH
- Bottom flange diameter: Ø0.188 (4 PLACES)
- Detail A: 10.00
- Detail B: 2.50 (REF)
- Detail C: 6.75
- Detail D: 3.227

D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

- Overall length: 28.50
- Overall width: 23.50
- Top flange width: 10.00
- Top flange thickness: 2.50 (REF)
- Bottom flange width: 23.50
- Bottom flange thickness: 2.432
- Bottom flange pitch: 4 EQUAL SPACES 5.875 PITCH
- Bottom flange diameter: Ø0.188 (2 PLACES)
- Detail A: 9.25
- Detail B: 2.50 (REF)
- Detail C: 2.50
- Detail D: 3.227

RELEASED
07.09.04

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN PH
DRAWN CB
CHECKED PH
MFG. APPR. PH
APPROVED PH
DE APPR. PH
DATE 07.08.21

DRAWING NO. D3564
TITLE WEARSHOE
REV. D
SHEET 2 OF 3
SCALE 1:8

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DRAWN	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	NO	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE 07.08.21		COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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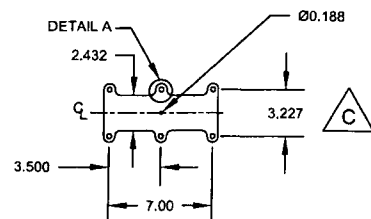
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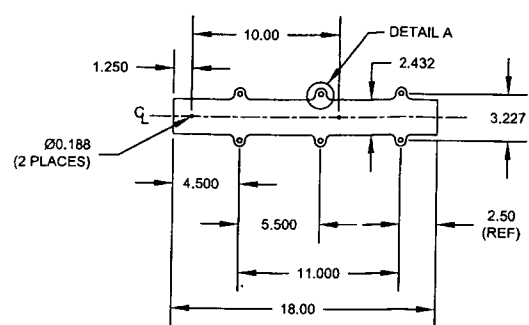
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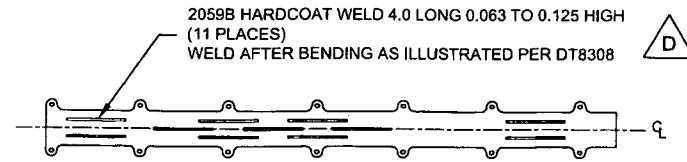
77614



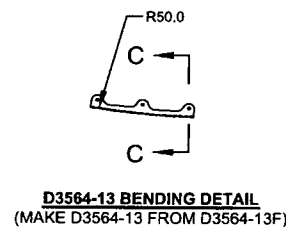
D3564-13F FLAT PATTERN



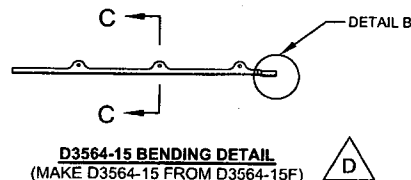
D3564-15F FLAT PATTERN



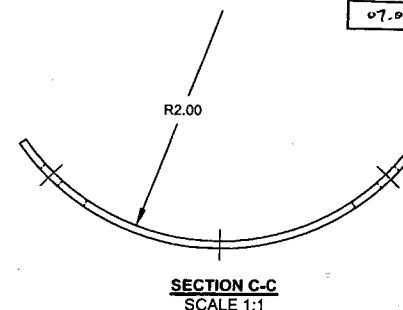
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



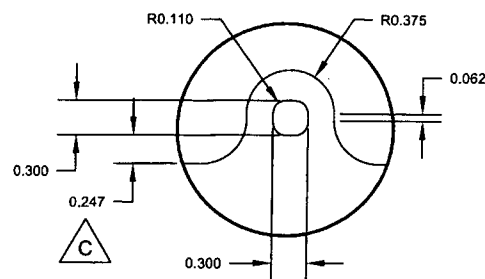
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



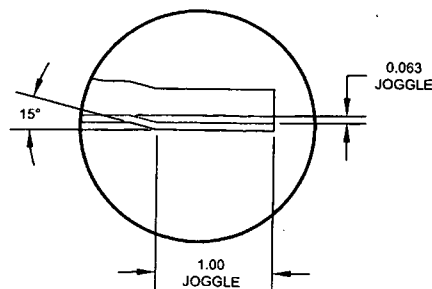
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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UNDER REVIEW
OK 07.11.28

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CHECKED	PH	DRAWING NO.	REV. D
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